



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2857-2

Job Sheet 198454



Part No: D2857-2

Job Qty: 20 pcs

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/30/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/19/19

Type: SOLD *skh*

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D 06.03.30

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		8/19/19	0.00	3.47	Bandsaw - 1		<i>SBL 19/09/15</i>
110	HAAS 4 Axis - B4B	20 pcs		8/19/19	0.18	9.62	HAAS - 1 - B4B		<i>SBL 19/09/15</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	20 pcs		8/19/19	0.00	0.00	QC 8 - 12		<i>On 19/09/16</i>
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S213784



Part: D2857-2

Job No: 198454

Serial No/Batch: S213784

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 09/16/19

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140 Handfinish - 1-1 Chemical-B4B	20 pcs	8/19/19	0.00 0.39	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SEP 17 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	20 pcs	8/19/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	31 12 9 15
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	

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				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
190 QC 21 - SA	20	8/19/19	0.00 0.00	QC 21 - SA - 21	21
	pcs			QC 21 - SA - 70	9-59
				QC 21 - SA - 53	

SEP 20 2019

Part Op 100 - (Bandsaw) Cut blanks 4.425"
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FA940 FOLIO REV: C
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - QC7-Inspect Chemical Conversion Coat
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X01.250	6061-T6 Bar 2.00 X 1.25 see mat'l	7.4000 ft (.37 ea)	100-Bandsaw - 1	S202789
	M6061T6B1.250X2.000			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.000X01.250	7	4	0

GAVE Chantal
to order

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches $\pm$ 0.010	4.310 4.290	4,300	
2	Hinge Bracket	4.000inches $\pm$ 0.010	4.010 3.990	4,000	
3	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330	,337	
4	Hinge Bracket	1.110inches $\pm$ 0.005	1.115 1.105	1,110	
5	Hinge Bracket	1.790inches $\pm$ 0.010	1.800 1.780	1,790	
6	Hinge Bracket	1.320inches $\pm$ 0.005	1.325 1.315	1,320	
7	Hinge Bracket	2.000inches $\pm$ 0.010	2.010 1.990	2,000	
8	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330	,340	
9	Hinge Bracket	0.447inches $\pm$ 0.010	0.457 0.437	,448	
10	Hinge Bracket	0.171inches + 0.005 - 0.000	0.176 0.171	,173	
11	Hinge Bracket	0.147inches $\pm$ 0.010	0.157 0.137	,142	
12	Hinge Bracket	0.376inches $\pm$ 0.010	0.386 0.366	,380	
13	Hinge Bracket	0.126inches $\pm$ 0.010	0.136 0.116	,123	
14	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053	,060	
15	Hinge Bracket	0.166inches + 0.005 - 0.000	0.171 0.166	,166	
16	Hinge Bracket	0.911inches $\pm$ 0.010	0.921 0.901	,910	
17	Hinge Bracket	0.600inches $\pm$ 0.010	0.610 0.590	,590	
18	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115	,130	
19	Hinge Bracket	0.150inches $\pm$ 0.010	0.160 0.140	150	

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Route update only

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